Work Order ID 103486 June-24-13 1:56:39 PM		*103	3486*					Page 1
Item ID: D3065-041 Revision ID: Item Name: Step Leg Assembly Start Date: 6/24/13 Start Qty: 40.00 Required Date: 7/06/13 Req'd Qty: 40.00		Accept	*N900040 Cust Item ID: Customer:	ገ1በ(Setup Star	ı V.	S1* S2*
Reference: Approvals: Process Plan: MUS QC:	Date: 13-00-76 Date:	Tooling: _ SPC (Y/N):	Date:			Run Star Sto	n ' 	R1* R2*
Sequence ID/ Operation Work Center ID Description	· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID Tool	# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr Revision Nbr								
D3065 Rev B	-							Α.
*100 * Small Fab Small Fab	per Dwg D3065 and Identi	0.00 0.00 fy as D3065-041			40x			Jszlor þ
2C5- Inspect part completed with the second	teness to step on W/O	0.00			40			0AS 19
120 Identify as per dwg & Stor *120* Packaging Memo	ck Location: <u>IW/A</u> .2902	0.00			40			13.09.20

Packaging

DQA:			Date:			-							***************************************	TOAC	ř
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UP		Work Order u	adata anly [\neg	AEROSPACE	
QA Closed.			Dutc.								work Order up	date only			
Work Orde	er:					DISPOSITION				AGAINST (IST DEPARTMENT/PROCESS				
						Rework			Skid-tube	Crosstube		Water Jet E			
Part N	No					Scrap			Machining	Small Fab	├ ──			Engineering Quality	
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other	
NCR I	۷o		1.411			Suspected Unapproved			Large Fab	Composite [Supplier			
	Τ-												· —	····	-
Root		Data	Cton	O4:	Desci	ription of work order update		nitial	Action		Sign &				
Cause	\vdash	Date	Step	Qty		or non-conformance	Cn	ief Eng	Descri	ption	Date	Verification	1	QC Inspector	_
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Equip/Tooling	\vdash														
Handling/Pre	\Box														
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Supplier															
Training															
Transport															
Unapproved															
							FAL	JLT CAT	regory						-
Landi	ng Gea	r				General					-	***		···-	
, t	Ве	nding				Bend		Folio/P	rogram	Γ	Outside Dim	ensions	Pre	essure/Forced	
	Ce	ntre No	t Concen	itric		BOM/Route		Grain			Over/Under	tolerance	Se	t-up	
	Cr	acks				Broken/Damage/Defect		Hardwa	re		Part Incorred	it .	Ter	mperature/Cure	
	Cri	mp/Kin	k/Ripple/	/Wave		Burrs		Inspecti	on Incomplete/Unc	qualified	Part Lost/Mi	ssing	We	eld	
	Cu	ffs				Contamination		Instruct	ions Incomplete/Ur	nclear	Part Moved	[\neg wr	rong Stock Pulled	į
	Cri	ushing				Countersink		Misalig	ned/off center		Positioned V	/rong			
,	He	at Trea	t			Cut Too Short		Mislabe	eled		Power Loss/:	Surge	Otl	her	
	_		Strip in	Tube		Drawing		Misread	i						Ī
	-	arks/Ch				Drill Holes		Off-set							
	\vdash		equence			Finish		Out of 0	Calibration						_
	w	ave/Twi	st in Tub	e		Fit/Function		Out of S	Sequence						•

Work Orde		3486		*103	3486*				Page 2
Item ID: Revision ID: Item Name:	D3065-041 Step Leg Ass	embly		Accept	*N90004	LN1NN*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	6/24/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item ID: Customer:				14632
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I	D .	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID To	ol# Plan Ac Code Qt	•	-	Reject Insp. Number Stamp
130		Memo		0.00			#	[fl ;	13-09-23

Quality Control

DQA:		Date	::		-							***	ANDT
QA Closed:		Date	<u>:</u>		WORK ORDER NON	-C(ONFO	RMANCE / UP		/ork Order up	odate only - [_	AEROSPACE
					DISPOSITION					EPARTMENT,	· ·		
Work Orde	er:					1	ļ						
Part N	No				Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	E	ngineering Quality
NCR N	No				Use-as-is Suspected Unapproved		Thern	noforming	Finishing Composite	Rec/Sto	re/Packaging Supplier		Other
Root				Desc	ription of work order update		Initial	Acti	on	Sign &			
Cause	Dat	e Step	Qty		or non-conformance	Ct	nief Eng	Descri	ption	Date	Verification		QC Inspector
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	Cracks	i			Broken/Damage/Defect		Hardwa	ire		Part Incorred	ct [Ten	nperature/Cure
- 1864	Crimp	/Kink/Ripp	le/Wave		Burrs		Inspecti	ion Incomplete/Und	qualified	Part Lost/Mi	ssing	We	ld -
	Cuffs				Contamination		Instruct	ions Incomplete/U	nclear	Part Moved	Ī	Wro	ong Stock Pulled
	Crush	ng			Countersink		Misalig	ned/off center		Positioned V	ے Vrong		
	Heat 1	reat			Cut Too Short		Mislabe	eled		Power Loss/	_	Oth	er
`	Inspec	tion Strip i	n Tube		Drawing		Misread	d		_		•	
	Marks	/Chatter			Drill Holes		Off-set						
,	Turnir	g Sequenc	e		Finish		Out of 0	Calibration					
	Wave	/Twist in Tu	ıbe		Fit/Function		Out of S	Sequence		-			

June-24-13 1:56:38 PM

Work Order ID:

103486

Parent Item:

D3065-041

Parent Item Name:

Step Leg Assembly

Start Date: 6/24/13

Required Date: 7/06/13

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
3065-1 ep Spacer	-	Manufactured	No	P	•	100	Each	81.0000	1	40		3/09/	/18
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ep Spacer							_		•		7	1	
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	•			101		56					BIO	4) 4 2	
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				837		12	2						
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				956	98	2					17		/ /
3065-5	:	Manufactured	No	•		100	Each	93.0000	2	80	<i>></i>	. 2 / 20	2/8
ep Leg											7	9/07	110
	100	13 711		Location		Loc Qty	<u>L</u>	oc Code			7	, , , , , , , , , , , , , , , , , , ,	2~~
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DQA:		_ Date:			-								74	
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / L		Wα	rk Order up	ndate only		AEROSPACE
					2.0200					•	·			
Work Orde	r:				DISPOSITION				AGAINST	DEP	ARTMENT	/PROCESS		
					Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part No	o				Scrap]		Machining	Small Fab		Pro	d. Eng. Coor.		Quality
					Use-as-is		Therr	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR N	0				Suspected Unapproved			Large Fab	Composite			Supplier		
Root	1.	Ī	· · ·	Dose	ription of work order update	T .	Initial	Λ.	ution.	- 1	C: 0			
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-	Cracks		6	_	Broken/Damage/Defect	<u> </u>	Hardwa			\vdash	Part Incorred		_	Temperature/Cure
<u> </u>	 1	ink/Ripple	/Wave		Burrs	<u> </u>	1	ion Incomplete/U		-	Part Lost/Mi	ssing	-	Weld
·, _	Cuffs			-	Contamination		-	ions Incomplete/	Unclear	\vdash	Part Moved		<u></u>	Wrong Stock Pulled
` -	Crushing				Countersink		-1	ned/off center		_	Positioned V			
	Heat Tre		- 1	<u> </u>	Cut Too Short	_	Mislabe				Power Loss/:	Surge		Other
	⊣ '	on Strip in	Tube	<u> </u>	Drawing	_	Misread	d		_				
	Marks/C			<u> </u>	Drill Holes	_	Off-set	- III		-	· · · · · · · · · · · · · · · · · · ·	<u></u>		
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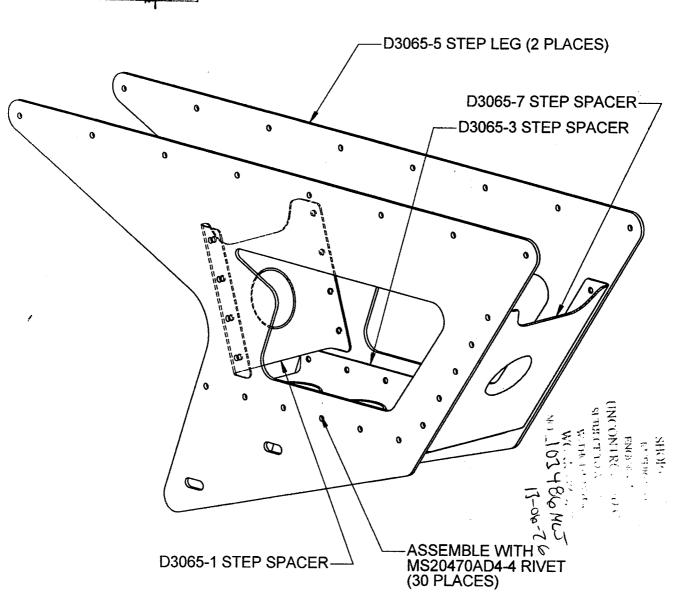
Work Order ID:	103486								
Parent Item:	D3065-041		'			;	Start I	Date: 6/24/13	Required Date: 7/06/13
Parent Item Name:	Step Leg Assembly		ė				Start	Qty: 40.00	Required Qty: 40.00
D3065-7		Manufactured	No		100	Each	82.0000	1	49
Step Spacer									9/3/09/18
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Rivet, Universal Head								CLOSE COMMON COM	9015/01/18
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DQA:			Date:										7	
OA Classed			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UPD					AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
	-					Rework			Skid-tube C	rosstube]	Water Jet		Engineering
Part N	No			_		Scrap			Machining S	Small Fab	Pro	d. Eng. Coor.		Quality
						Use-as-is		Therr	moforming	Finishing	Rec/Stor	re/Packaging		Other
NCR I	No			··		Suspected Unapproved			Large Fab Co	omposite		Supplier	,	
Root	Т				Desc	ription of work order update	ı	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	on	Date	Verification	n	QC Inspector
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Doc/Data	Ш													
Equip/Tooling	Ш													
Handling/Pre	Ш													
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Operator														
Offset/Setup	Ш													
Process	Ш													
Supplier	Ш													
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Unapproved														
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	∐В	ending				Bend		Folio/P	rogram		Outside Dim	ensions		Pressure/Forced
	Щc	entre No	t Concen	tric		BOM/Route		Grain			Over/Under	tolerance		Set-up
	∐c	racks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	:t		Temperature/Cure
	∐_c	rimp/Kir	ık/Ripple,	/Wave		Burrs		Inspecti	ion Incomplete/Unqua	lified	Part Lost/Mi:	ssing		Weld
		uffs				Contamination		Instruct	ions Incomplete/Uncle	ear	Part Moved			Wrong Stock Pulled
	c	rushing				Countersink		Misalig	ned/off center		Positioned W	rong/		
	Н	eat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/S			Other
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		1arks/Ch	atter			Drill Holes		Off-set				 .		
	Т	urning So	equence			Finish		Out of 0	Calibration					
	V	/ave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence					



DESIGN	4	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA					
CHECK		APPROVED	DRAWING NO.	REV. B				
	PH		D3065	SHEET 1 OF 5				
DATE	06.0)E 00	TITLE	SCALE				
	06.0	05.23	STEP LEG ASSEMBLY	1:2				
Α	0:	2.09.11	NEW ISSUE					
В	0	6.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5					

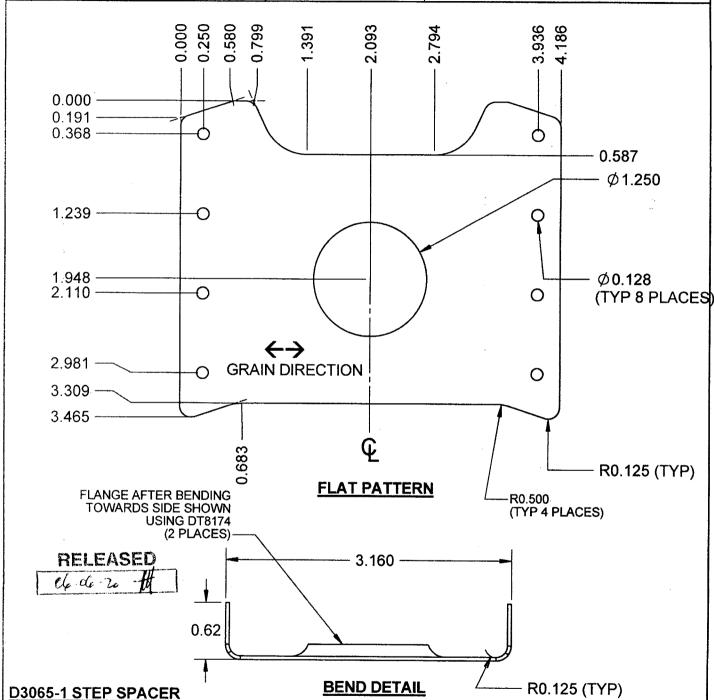
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D3065-041 STEP LEG ASSEMBLY





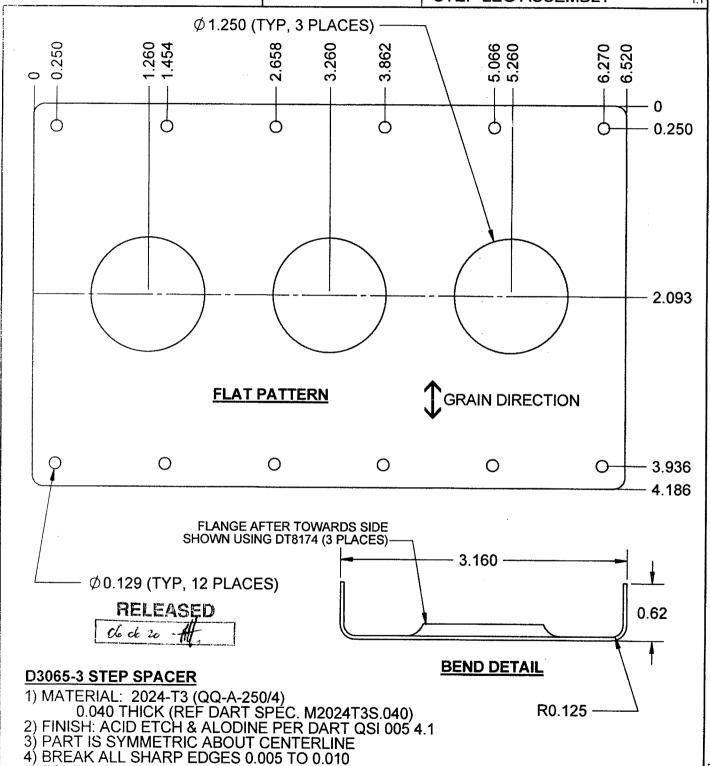


- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

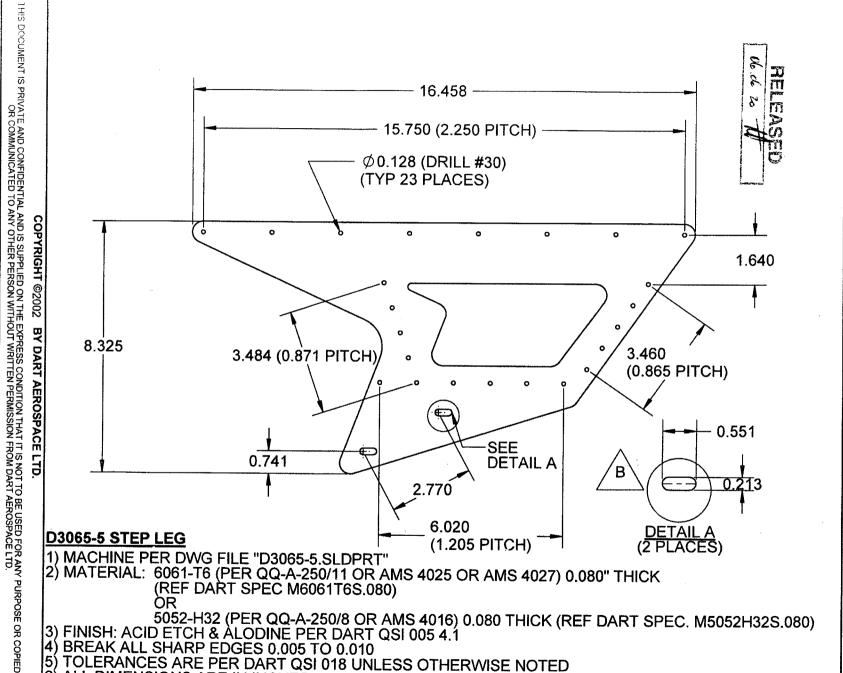
6) ALL DIMENSIONS ARE IN INCHES

DATE 06.05. \$ 23 DRAWING NO. D3065 STEP LEG DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA ASSEMBLY

SHEET 4 OF 5

SCALE

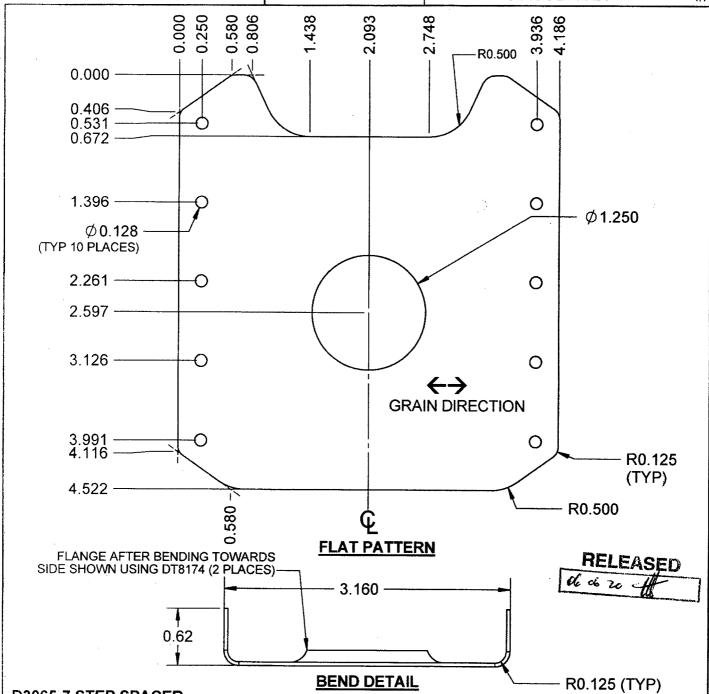
REV. B



BREAK ALL SHARP EDGES 0.005 TO 0.010
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES







D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040) 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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